

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 71929

Wednesday, July 13, 2011 12:52:52 PM

Page 2

Item ID: D4275-1

Accept

Revision ID:

Item Name: Fwd Beam

Start Date: 7/13/2011 Start Qty: 2.00

Required Date: 7/29/2011 Req'd Qty: 2.00

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

Quality Control

130

QC8- Inspect parts - second check

0.00

QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00

HandFinish

Memo

0.00

Hand Finishing



Cust Item ID:

Customer:



SLA 11/07/26

SL 11-07-28

2

x2 g 11/02/18

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Accept

Page 4

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Wednesday, July 13, 2011 12:52:52 PM

Item ID: D4275-1

Revision ID:

Item Name: Fwd Beam

Start Date: 7/13/2011 Start Qty: 2.00

Required Date: 7/29/2011 Req'd Qty: 2.00

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

145



Powdercoat

Powder Coating

Operation
Description

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

Memo

MASK AS PER DWG

Set Up/
Run Hours

0.00

0.00

0.00

0.00

0.00

0.00

0.00

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

2 0 BL 11-7-28

2 4 ML 11-07-28

2 10 11-07-29

150



QC

Quality Control

QC3- Inspect Part Finish

Memo

180



Packaging

Packaging

Identify as per dwg & Stock Location:

Memo

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H:\FORMS\Quality Assurance\approved QANCRWO RevE

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H:\FORMS\Quality Assurance\approved QANCRWO RevE

Picklist Print

Wednesday, July 13, 2011 12:52:49 PM

Page 1

Work Order ID: 71929

Parent Item: D4275-1

Parent Item Name: Fwd Beam



Start Date: 7/13/2011

Required Date: 7/29/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A NEW ISSUE 10-11-17 JLM VERIFIED BY:DD IPP rev:B
10.12.02 AS PER DWG REV.A DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.000X04.00 0		Purchased	No			100	f	26.3100	3.3125	6.973684			



6061-T6 Bar 1.00 x 4.00



FK 11/07/26

Location	Loc Qty	Loc Code
MAT004	26.31	
107221	22.23	
114352	2.58	
116808	1.5	

6.625

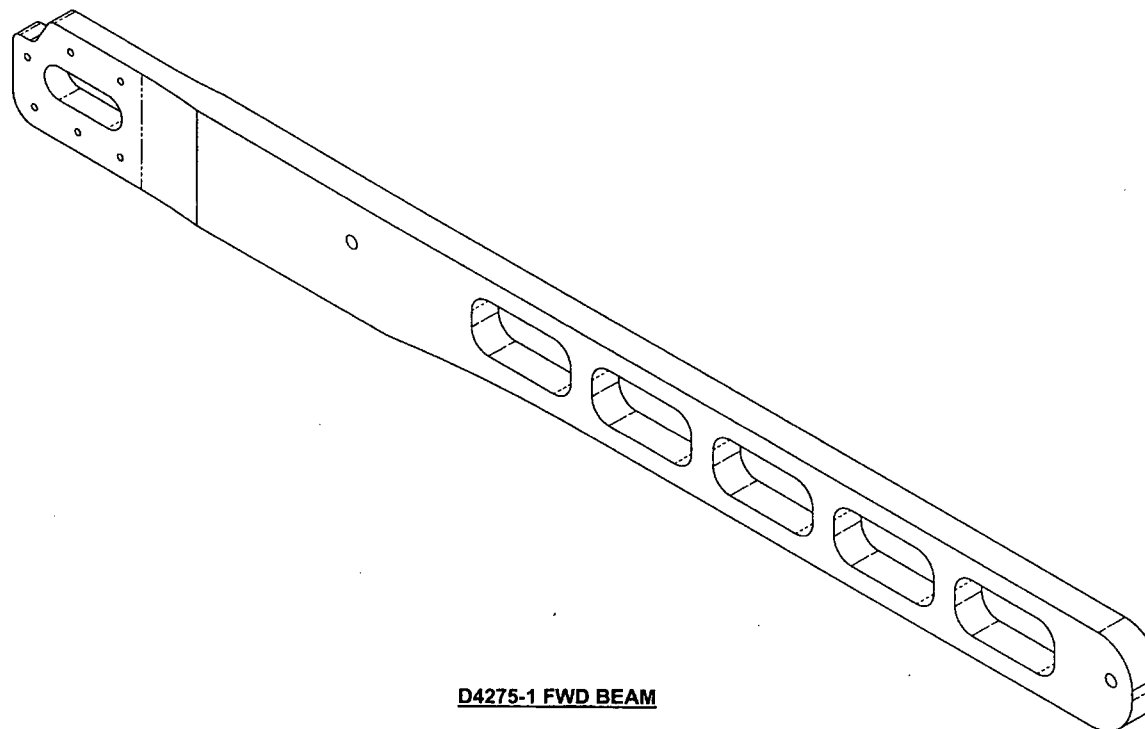
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D4275-1 FWD BEAM

RELEASED
2010-11-30
JWB

#71929

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 8.29 lbs
- 8) MASK HOLES PRIOR TO POWDER COAT.

A	NEW ISSUE	SC	10.11.25
REV.	DESCRIPTION		BY DATE
DESIGN	SC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	#	DRAWING NO.	REV. A
MFG. APPR.	#	D4275	SHEET 1 OF 2
APPROVED	#	TITLE	SCALE
DE APPR.	#	FWD BEAM	NTS
DATE	10.11.25	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

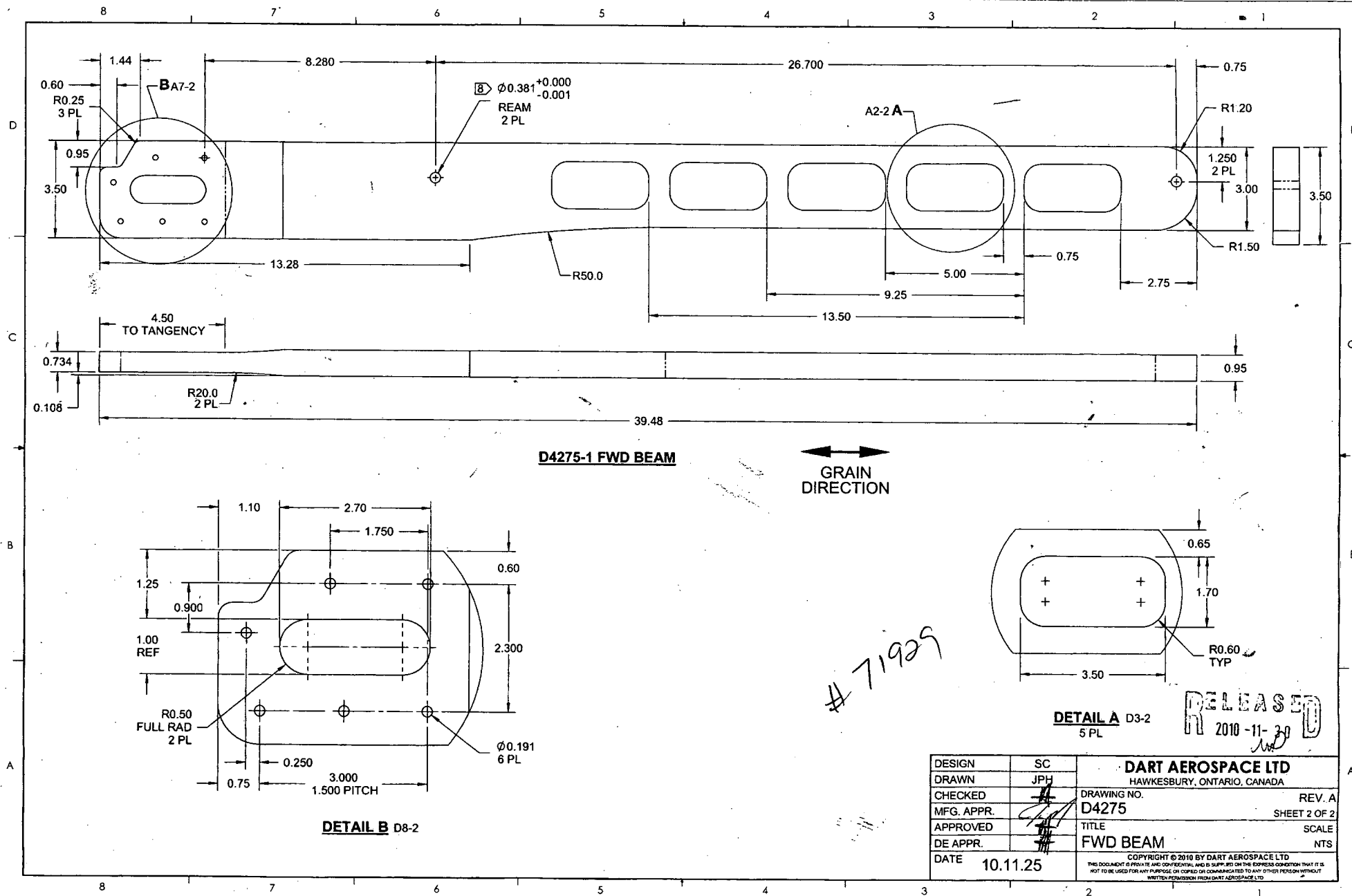
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DART AEROSPACE LTD	Work Order: 71929
Description: FWD BEAM	Part Number: D4275-1
Inspection Dwg: D4275 Rev: A	Page 1 of 2

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.75	+/- .030	0.752	✓		Vern	GA-01
26.700	+/- .010	26.700	✓		Tape	GA-12
Ø0.381	+0.000/-0.001	Ø0.381	✓		Mic	GA-03
8.280	+/- .010	8.280	✓		H-G	31006
1.44	+/- .030	1.440	✓		Vern	GA-01
0.95	+/- .030	0.945	✓		"	"
3.50	+/- .030	3.500	✓		"	"
13.28	+/- .030	13.275	✓		Tape	GA-12
13.50	+/- .030	13.500	✓		"	"
9.25	+/- .030	9.251	✓		Vern	CNC-02
5.00	+/- .030	5.000	✓		Vern	GA-01
0.75	+/- .030	0.751	✓		"	"
2.75	+/- .030	2.749	✓		"	"
3.00	+/- .030	3.000	✓		"	"
1.250	+/- .010	1.251	✓		"	"
4.50	+/- .030	4.500	✓		"	"
0.734	+/- .010	0.736	✓		"	"
Ø108	+/- .010	Ø.102	✓		H-G	31006
39.48	+/- .030	39.475	✓		Tape	GA-12
0.95	+/- .030	0.949	✓		Vern	GA-01
0.60	+/- .030	0.597	✓		"	"
1.750	+/- .010	1.750	✓		"	"
2.700	+/- .010	2.699	✓		"	"

Measured by: B.A	Audited by: JL	Preliminary Approval:
Date: 11/07/26	Date: 11-07-28	Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15

